

Date: Wednesday, 5/31/2006 7:35:58 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET ASSEMBLY  
 Job Number : 27282  
 Estimate Number : 11029  
 P.O. Number : N/A Part Number : D2803041  
 This Issue : 5/31/2006 S.O. No. : N/A Drawing Number : D2803 REV B  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : B  
 Previous Run : 25917 Material : N/A  
 Written By : *See Comment Below* Due Date : 6/20/2006 Qty: *30* Um: Each  
 Checked & Approved By : *06.05.31*  
 Comment : EST F 05.03.30 MS21043-3 was MS21042L3 KJ/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D28031 STA 84 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)  
 STA 84 BRACKET

Pick:

Qty	Part Number	Description	Batch
1	D2803-1	Bracket	B 27301 (10) B23635 (10)

2.0 D28051 Stop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)  
 STOP

Pick:

Qty	Part Number	Description	Batch
1	D2805-1	Stop	B27304 (16) B27113 (4)

D2809 Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)  
 Bushing

Pick:

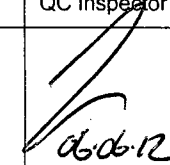
Qty	Part Number	Description	Batch
1	D2809	Bushing	B 27306

Press D2805-1 into arm as per Dwg D2803


4.0 *QCS* INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
060612	4	QC5 required, Remove QC2 permanent change. 2					 06-06-12	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:  Date: 06/06/12

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Wednesday, 5/31/2006 7:35:58 AM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 27282

Part Number: D2803041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/06/19 (20)

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 06-06-20 20

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2809 into arm as per Dwg D2803

FF 06-06-20 20

8.0

AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 32.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch

2 AN3C16A Bolt M 101189

9.0

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 32.0000 Each(s)

Nut

Pick:

Qty Part Number Description Batch

2 MS21043-3 Nut M 19099

10.0

NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 64.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

4 NAS1515H3 Washer M 19633

A/R LPS-3 Corrosion Spray M 17395

Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2803

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Wednesday, 5/31/2006 7:35:58 AM  
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Drawing Name: BRACKET ASSEMBLY

Job Number: 27282

Part Number: D2803041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble as per Dwg D2803.

H.M 06-06-20

(20)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/06/20

(20)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: 57105

06/06/20 (24)

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

06/06/21 (20)

Job Completion



u 06.06.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

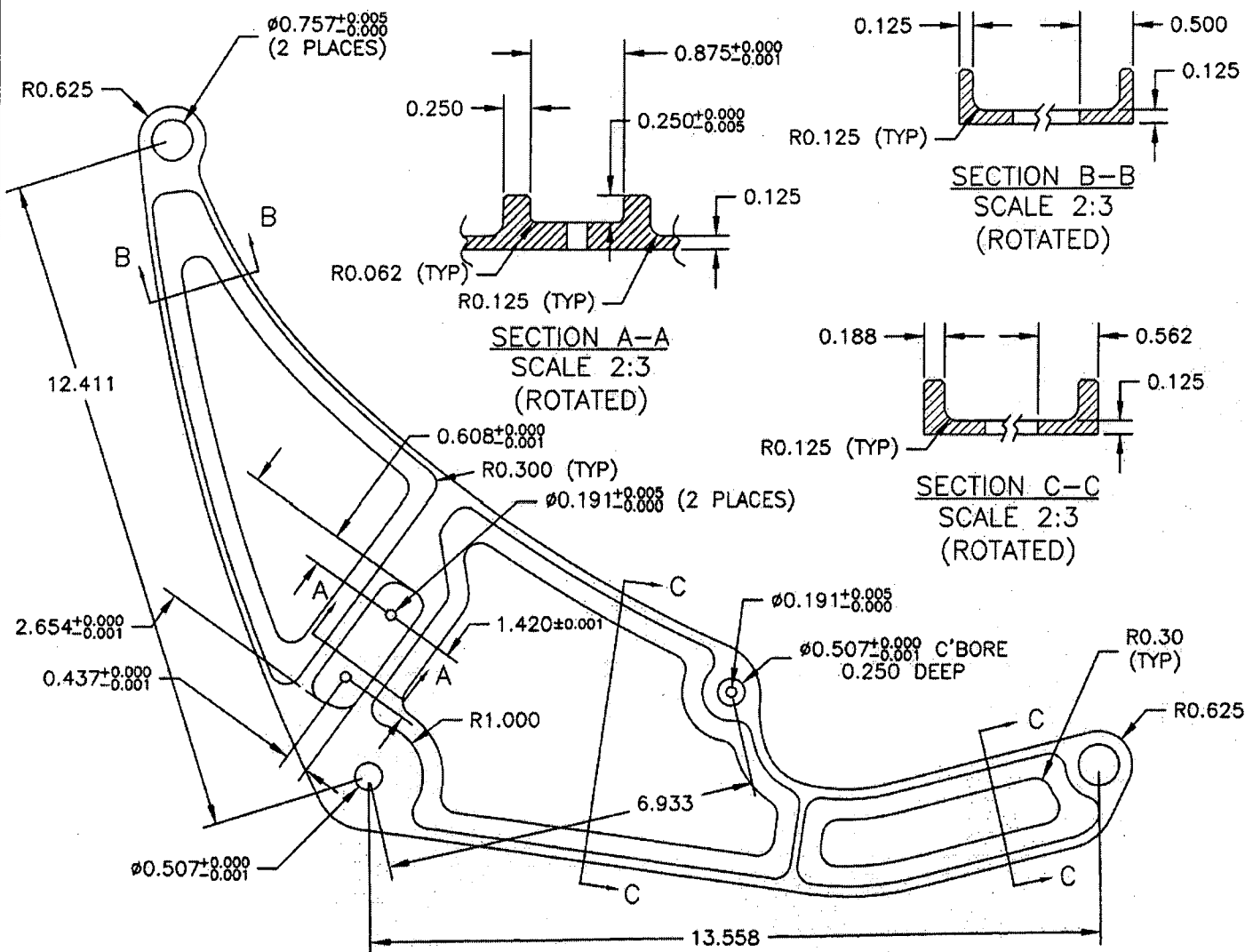
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2803	SHEET 1 OF 2
DATE	04.11.22	TITLE	STA 84 BRACKET	SCALE	1:3
A	00.11.07	NEW ISSUE			
B	04.11.22	ADD CUTOUTS & -043/-044			

RELEASED

05-03-11 *[Signature]***D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

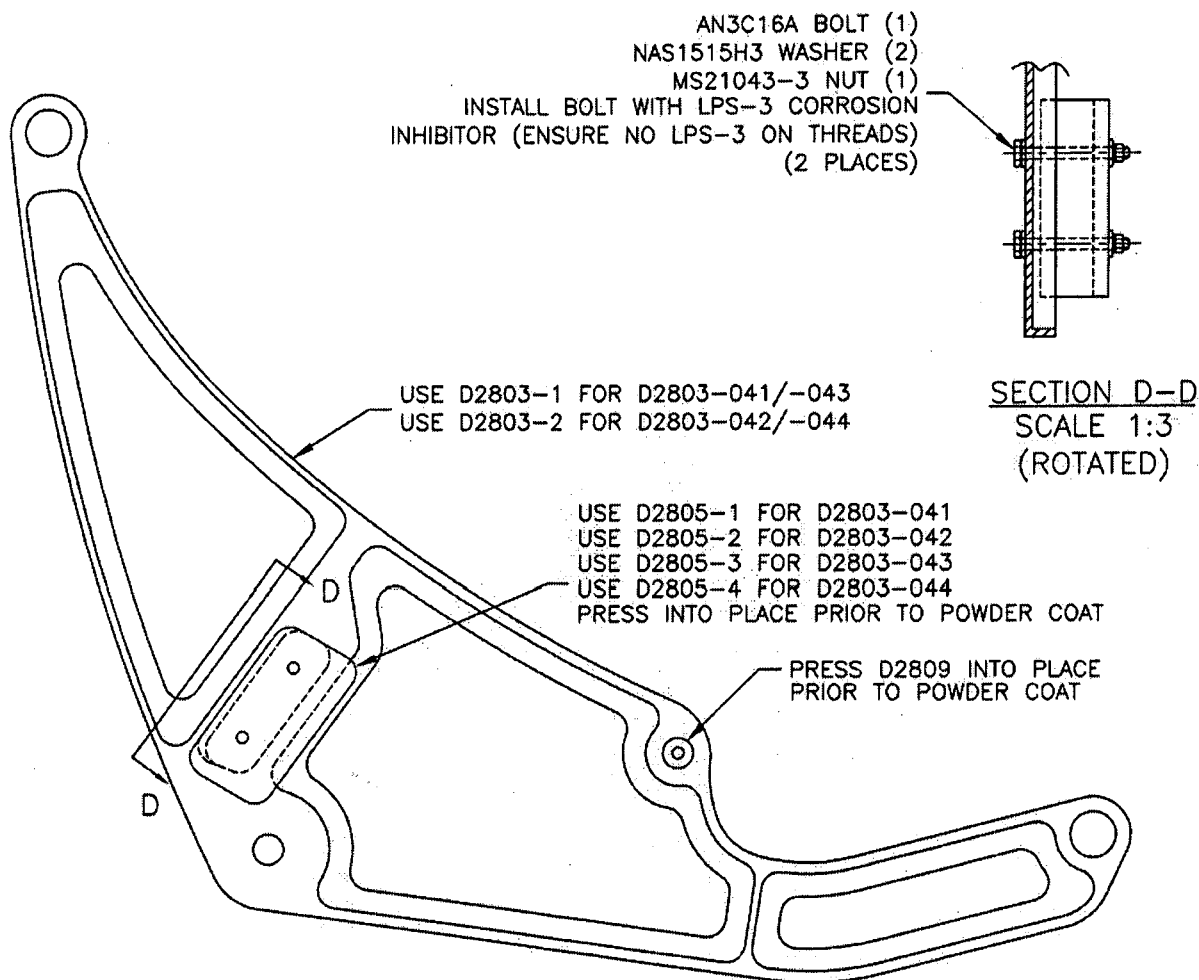
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NO. 27282

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**DART**

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3



**D2803-041/-043 BRACKET ASS'Y (SHOWN)**  
**D2803-042/-044 BRACKET ASS'Y (OPPOSITE)**

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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